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INTERNATIONAL FILING DATE

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TITLE OF INVENTION

DISPLAY

APPLICANT(S) FOR DO/EO/US

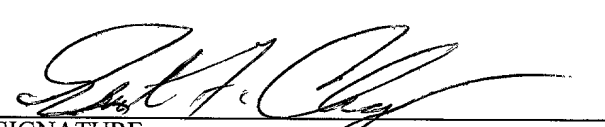
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Applicants herewith submit to the United States Designated/Elected Office (DO/EO/US) the following items and other information:

1. ☒ This is a **FIRST** submission of items concerning a filing under 35 U.S.C. 371.
2. ☐ This is a **SECOND** or **SUBSEQUENT** submission of items concerning a filing under 35 U.S.C. 371.
3. ☐ This is an express request to begin national examination procedures (35 U.S.C. 371(f)). The submission must include items (5), (6), (9) and (21) indicated below.
4. ☐ The US has been elected by the expiration of 19 months from the priority date (Article 31).
5. ☒ A copy of the International Application as filed (35 U.S.C. 371 (c)(2)).
 - a. ☐ is attached hereto (required only if not communicated by the International Bureau).
 - b. ☒ has been communicated by the International Bureau.
 - c. ☐ is not required, as the application was filed with the United States Receiving Office (RO/US).
6. ☒ An English language translation of the International Application as filed (35 U.S.C. 371 (c)(2)).
 - a. ☒ is attached hereto.
 - b. ☐ has been previously submitted under 35 U.S.C. 154 (d)(4).
7. ☒ Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371 (c)(3)).
 - a. ☒ are attached hereto (required only if not communicated by the International Bureau).
 - b. ☐ have been communicated by the International Bureau.
 - c. ☐ have not been made; however, the time limit for making such amendments has NOT expired.
 - d. ☐ have not been made and will not be made.
8. ☐ An English language translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371 (c)(3)).
9. ☐ An oath or declaration of the inventor(s) (35 U.S.C. 371 (c)(4)).
10. ☐ An English language translation of the annexes of the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371 (c)(5)).

Items 11 to 20 below concern document(s) or information included:

11. ☐ Information Disclosure Statement under 37 CFR 1.97 and 1.98.
12. ☐ An assignment document for recording. A separate cover sheet in compliance with 37 CFR 3.28 and 3.31 is included.
13. ☐ A **FIRST** preliminary amendment.
14. ☐ A **SECOND** or **SUBSEQUENT** preliminary amendment.
15. ☐ A Substitute specification.
16. ☐ A change of power of attorney and/or address letter.
17. ☐ A computer-readable form of the sequence listing in accordance with PCT Rule 13ter.2 and 35 U.S.C. 1.821-1.825.
18. ☐ A second copy of the published international application under 35 U.S.C. 154 (d)(4).
19. ☐ A second copy of the English language translation of the international application 35 U.S.C. 154 (d)(4).
20. ☒ Other items or information:
 - a. ☒ Copy of cover page of International Publication No. WO01/37246.
 - b. ☐ Copy of Notification of Missing Requirements.

U.S. APPLICATION NO. (if known, see 37 CFR 1.53) 09/889319		INTERNATIONAL APPLICATION NO PCT/JP00/08094		Attorney's Docket Number 01165.0822	
21. <input checked="" type="checkbox"/> The following fees are submitted: BASIC NATIONAL FEE (37 CFR 1.492 (a) (1) - (5)): Neither international preliminary examination fee (37 CFR 1.482) nor international search fee (37 CFR 1.445(a)(2)) paid to USPTO and International Search Report not prepared by the EPO or JPO\$1000.00 International preliminary examination fee (37 CFR 1.482) not paid to USPTO but International Search Report prepared by the EPO or JPO\$860.00 International preliminary examination fee (37 CFR 1.482) not paid to USPTO but International Search fee (37 CFR 1.445(a)(2)) paid to USPTO\$710.00 International preliminary examination fee (37 CFR 1.482) paid to USPTO but all claims did not satisfy provisions of PCT Article 33(1)-(4)\$690.00 International preliminary examination fee (37 CFR 1.482) paid to USPTO and all claims satisfied provisions of PCT Article 33 (1)-(4)\$100.00 <div style="text-align: right;">ENTER APPROPRIATE BASIC FEE AMOUNT =</div>				CALCULATIONS PTO USE ONLY	
Surcharge of \$130.00 for furnishing the oath or declaration later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492 (e)).				\$	
CLAIMS	NUMBER FILED	NUMBER EXTRA	RATE		
Total Claims	11	- 20 =	0	x \$18.00	\$
Independent Claims	1	- 3 =	0	x \$80.00	\$
MULTIPLE DEPENDENT CLAIM(S) (if applicable)			+\$270.00	\$270.00	
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SEND ALL CORRESPONDENCE TO: Finnegan, Henderson, Farabow, Garrett & Dunner, L.L.P. 1300 I Street, N.W. Washington, D.C. 20005-3315 EFC/FPD/sci DATED: July 13, 2001					
 SIGNATURE Ernest F. Chapman /Reg. No. 25,961 NAME/REGISTRATION NO.					

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- 1 -

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SPECIFICATION

A DISPLAY DEVICE

TECHNICAL FIELD

5 The present invention relates to a display device
having a display cell and, in particular, relates to a
liquid crystal display device having a liquid crystal
panel formed of a drive cell as one example of a display
cell, and a correction cell as one example of a display
10 cell having a phase difference function. According to
the present invention, it is possible to resolve
unfavorable and undesirable color which occurs in
peripheral portions of the liquid crystal panel.

15 BACKGROUND ART

As display devices, there are a liquid crystal
display device, an EL display device and a plasma display
device, each using a display cell. In particular, the
liquid crystal display device having the cell filled with
the liquid crystal, as a main portion, is a thin type and
has a small power consumption, so that it is been widely
utilized individually or as display means for a computer,
a communication equipment and the like. As a
representative liquid crystal display device, there is a
20 known liquid crystal display device using a TN liquid
crystal or a STN liquid crystal utilizing the optical
rotatory power of the liquid crystal.

In the liquid crystal display device using such
liquid crystal, in general, linear polarization of light
30 passing through a polarization board is utilized. In
this case, due to an optical anisotropy of liquid
molecules in a liquid crystal layer, the incident light
is divided into an ordinary ray (O) and an extraordinary
ray (E). When the light comes out from the liquid
35 crystal layer, a phase difference occurs between these
rays. The phase difference results in unfavorable and
undesirable color of an outgoing ray of the liquid

- 2 -

crystal cell, as is well known in this field.

Accordingly, in order to prevent such color at the outgoing ray, there is a liquid crystal panel including a liquid crystal cell having a structure, in order to
5 correct the phase difference, in which a normal liquid crystal cell (a drive cell) having drive electrodes is overlapped with a liquid crystal cell (a correction cell) having a function of a phase difference board (i.e., the function for correcting the phase difference due to
10 birefringence of the drive cell).

However, even in such structure, in which the conventional drive cell is overlapped with the correction cell, unfavorable and undesirable color has been not sufficiently eliminated.
15

ABSTRACT OF THE INVENTION

Therefore, an object of the present invention is to provide a liquid crystal display device, which can resolve the above-mentioned conventional problem of the liquid crystal display device, i.e., reduction of display
20 quality due to unfavorable and undesirable color, which occurs due to a defective area in the vicinity of a seal member of the liquid crystal cell.

Further, another object of the present invention is to provide a liquid crystal display device including an optimum size having economically useful structure.
25

As a first means to resolve the above problem, the present invention includes a display device comprising; at least one display cell sealed by one seal member in
30 which an electro-optical converting member (for example, a liquid crystal) is held; another at least one display cell sealed by another seal member in which the electro-optical converting member is held; and these display cells being overlapped; characterized in that the display
35 cell provided to an opposite side of an observer has a normal area which is wider than the display cell provided to a side of the observer.

- 3 -

As a second means to resolve the above problem, the present invention includes a liquid crystal device comprising at least one liquid crystal display cell sealed by one seal member in which a liquid crystal is held; another at least one liquid crystal display cell sealed by another seal member in which the liquid crystal is held; and these liquid crystal display cells being overlapped; characterized in that the liquid crystal display cell provided to an opposite side of an observer has a normal area which is wider than the liquid crystal display cell provided to a side of the observer.

As a third means to resolve the above problem, the present invention includes a liquid crystal device comprising a drive cell sealed by a seal member in which a liquid crystal is held; and to which a drive voltage for the liquid crystal is applied; a correction cell sealed by a seal member in which the liquid crystal is held, and to which the drive voltage for the liquid crystal is not applied; and these drive cell and correction cell being overlapped; characterized in that one of outside sizes of the drive cell and the correction cell is larger than the other outside size.

As a fourth means to resolve the above problem, the present invention includes a liquid crystal device comprising a drive cell sealed by a seal member in which a liquid crystal is held; and to which a drive voltage for the liquid crystal is applied; a correction cell sealed by a seal member in which the liquid crystal is held, and to which the drive voltage for the liquid crystal is not applied; and these drive cell and correction cell being overlapped; characterized in that one of inside sizes of the seal member of the drive cell and the seal member of the correction cell is larger than the other inside size.

As a fifth means to resolve the above problem, the present invention includes a liquid crystal device comprising a drive cell sealed by a seal member in which

- 4 -

a liquid crystal is held, and to which a drive voltage for the liquid crystal is applied; a correction cell sealed by a seal member in which the liquid crystal is held, and to which the drive voltage for the liquid crystal is not applied; and these drive cell and correction cell being overlapped; characterized in that one of sizes of an effective display area of the drive cell and the effective display area of the correction cell is larger than the other size of the effective display area.

As a sixth means to resolve the above problem, in any one of the second to fifth means, the liquid crystal panel is structured as being overlapped between the drive cell and the correction cell, in the form that a defective area having defects of a cell gap and/or of an alignment in the vicinity of the inside of the seal member of the drive cell is overlapped in the range of the normal area having no defects of the correction cell.

As a seventh means to resolve the above problem, in the fifth means, the liquid crystal panel is structured as being overlapped between the drive cell and the correction cell, in the form that a defective area having defects of a cell gap and/or of an alignment in the vicinity of the inside of the seal member of the correction cell is overlapped in the range of the normal area having no defects of the drive cell.

As a eighth means to resolve the above problem, in the sixth means, the liquid crystal panel is structured as being overlapped between the drive cell and the correction cell, in the form that the whole liquid crystal area of the inside of the seal member of the drive cell is overlapped in the range of the normal area having no defect, inside of the defective area having defects of a cell gap and/or of an alignment in the vicinity of the inside of the seal member of the correction cell.

As a ninth means to resolve the above problem, in

- 5 -

the seventh means, the liquid crystal panel is structured as being overlapped between the drive cell and the correction cell, in the form that the whole liquid crystal area of the inside of the seal member of the correction cell is overlapped in the range of the normal area having no defect, inside of the defective area having defects of a cell gap and/or of an alignment in the vicinity of the inside of the seal member of the drive cell.

As a tenth means to resolve the above problem, in any one of the second means to the ninth means, the liquid crystal is an STN liquid crystal.

BRIEF EXPLANATION OF THE DRAWINGS

Figure 1 is a cross-sectional view showing a liquid crystal panel structure having a correction cell according to one embodiment of the present invention;

Figure 2 is a cross-sectional view showing a liquid crystal panel structure according to another embodiment of the present invention;

Figure 3 is a cross-sectional view showing a liquid crystal panel structure according to still another embodiment of the present invention;

Figure 4 is a cross-sectional view showing a modified structure of the liquid crystal panel shown in Fig. 3;

Figure 5 is a cross-sectional view showing a liquid crystal panel structure having a correction cell according to a conventional liquid crystal display device;

Figure 6 is a perspective view showing an essential alignment state at the liquid crystal panel shown in Fig. 5; and

Figure 7 is a perspective view showing an essential alignment state including the defective area at the liquid crystal panel shown in Fig. 5.

- 6 -

BEST MODE FOR CARRYING OUT THE PRESENT INVENTION

Before explanations of preferable embodiments of the present invention are given, a conventional art and its problem will be explained with reference to the drawings.

5 In this case, in the following explanations, rays S1 and S2 are used for explaining an action causing the color, and do not indicate an observer's eyes. That is, the object of the present invention is to resolve the undesirable and unfavorable color, which occurs in
10 peripheral portions of the display panel when it is observed by the observer, and to determine the optimum size of the display cell having economically useful structure based on visual difference due to the observer's eyes. Accordingly, the rays S1 and S2 are
15 used for analyzing the color.

Figure 5 is the cross-sectional view showing the liquid crystal panel 110 having the correction cell according to the conventional liquid crystal display device. In Fig. 5, 101 denotes the drive cell. In the
20 drive cell 101, 120a denotes the STN liquid crystal layer, and consists of the normal area 120a1 and the defective area 120a2 as explained below, which are held by a transparent upper substrate 102 and a transparent lower substrate 103 surrounded by a seal member 108.
25 104a denotes an upper drive electrode, and formed closely on a lower surface of the upper substrate 102. 105a denotes an upper alignment film formed closely on the lower surface of the upper substrate 102 by covering the upper drive electrode 104a. 104b denotes a lower drive
30 electrode, and it is formed closely on an upper surface of the lower substrate 103. 105b denotes a lower alignment film formed closely on the upper surface of the lower substrate 103 by covering the lower drive electrode 104b.

35 Number 111 denotes the correction cell. In the correction cell 111, the STN liquid crystal 120b is the STN liquid crystal layer, and consists of the normal

- 7 -

area 120b1 and the defective area 120b2 as explained below, which are held by a transparent upper substrate 112 and a transparent lower substrate 113 surrounded by the seal member 108. However, there is no drive electrode, which is different from the drive cell 101. 115a denotes the upper alignment film formed closely on the lower surface of the upper substrate 112. Number 115b denotes the lower alignment film formed closely on the upper surface of the lower substrate 113.

As shown in Fig. 5, an inner size of the seal member of the drive cell 101 is approximately equal to the inner size of the seal member of the correction cell 111, the normal area 120a1 of the drive cell 101 is overlapped with the normal area 120b1 of the correction cell 111, and the defective area 120a2 of the drive cell 101 is overlapped with the defective area 120b2 of the correction cell 111. 121 denotes a first polarization board, and is arranged closely on or opposite to the outside (upper side) of the upper substrate 102 of the drive cell 101. 122 denotes a second polarization board, and is arranged closely on or opposite to the outside (lower side) of the lower substrate 113 of the correction cell 111.

Figure 6 is the perspective view showing a polarizing direction of each polarization board and an alignment direction (direction of an optical axis) at the normal area (120a1 and 120b1) of the liquid crystal layer. X- and Y- coordinates are provided for each member as a common coordinate. A rotational direction is determined based on the X-axis.

The action of the liquid crystal panel having the above structure is basically similar to the liquid crystal panel having the "phase difference board" except for the defective areas 120a2 and 120b2 in the vicinity of the seal member 108.

The action of the liquid crystal panel 110 will be explained with reference to Figs. 5 and 6 below. First,

- 8 -

the explanation is given to the action of the ray S1 which is input from the outside to the first polarization board 121, passes through the normal area 120a1 of the drive cell 101, the normal area 120b1 of the correction cell and the like on the way, and is finally output from the second polarization board 122. The polarizing direction of the first polarization board 121 is -15° , the ray S1 input to the polarization 121 is output as the linear polarization having the direction of -15° , and input to the normal area 120a1 of the STN liquid crystal layer through the upper substrate 102 of the drive cell 101 and the upper alignment film 105a.

In the drive cell 101, due to the alignment of the upper alignment film 105a, the direction of the optical axis of the liquid crystal molecule at the upper surface of the normal area 120a1 is $+210^\circ$ (direction opposite to $+30^\circ$). Due to the alignment of the lower alignment film 105b, the direction of the optical axis of the liquid crystal molecule at the lower surface of the normal area 120a1 is -30° , and the optical axis of the STN liquid crystal at the normal area 120a1 is rotated to the left direction by 240° (rotation like a left-handed screw for the moving direction of the light).

The ray S1 is input to the polarization direction of 45° for the optical axis at the upper surface of the STN liquid crystal layer 120a1 (normal area) as the linear polarization, and separated to the extraordinary ray (E), which oscillates in the direction parallel to the optical axis, and the ordinary ray (O) which oscillates in the direction perpendicular to the optical axis. Further, the ray S1 moves with optical rotation and passes through the lower surface of the STN liquid crystal layer 120a1 (normal area). At that time, the extraordinary ray occurs the phase difference δ_1 for the ordinary ray. The ray, which passes through the lower surface of the STN liquid crystal layer 120a1 (normal area), is formed as an elliptically polarized light having the oscillating

- 9 -

direction (direction of the optical axis of -30°) of the extraordinary ray (E), the oscillating direction (perpendicular direction of $+60^\circ$) and a component of the phase difference $\delta 1$. Further, the ray is input to the

5 STN liquid crystal layer 120b1 (normal area) of the correction cell, passing through the lower alignment film 105b, the lower substrate 103 of the drive cell 101, the upper substrate 112 of the correction cell 111 and the upper alignment film 115a of the correction cell 111.

10 In the correction cell 111, due to the alignment of the upper alignment film 115a, the direction of the optical axis of the liquid crystal molecule at the upper surface of the normal area 120b1 is $+60^\circ$. Due to the alignment of the lower alignment film 115b, the direction
15 of the optical axis of the liquid crystal molecule at the lower surface of the normal area 120b1 is -60° . The optical axis of the STN liquid crystal at the normal area 120b1 is rotated to the right direction by 240° (rotation like a right-handed screw for the moving
20 direction of the light).

In the incident light, a light component at the oscillating direction (-30°) of the extraordinary ray (E) is input based on the oscillating direction having an angle of approximately perpendicular, moved by 90° , to
25 the direction of the optical axis $+60^\circ$, at the upper surface of the STN liquid crystal layer 120b1 (normal area) of the correction cell, so that the component becomes a main component of the ordinary ray (O).

Another light component at the oscillating
30 direction ($+60^\circ$) of the ordinary ray is input based on the oscillating direction having an angle of approximately parallel, having 0° , to the direction of the optical axis $+60^\circ$, at the upper surface of the STN liquid crystal layer 120b1 (normal area) of the
35 correction cell, so that the component becomes a main component of the extraordinary ray (E). In this case, the extraordinary ray (E) has the phase difference of

- 10 -

approximately - δ_1 for the ordinary ray (O).

The ordinary ray (O) and extraordinary ray (E) are moved with the rotation of the optical axis at the STN liquid crystal layer 120b1 (normal area), and are passed at the lower surface of the STN liquid crystal layer 120b1 (normal area). At that time, the phase difference of the extraordinary ray (E) is increased by δ_2 for the ordinary ray (O), and becomes $(\delta_2 - \delta_1)$. When the final phase difference $(\delta_2 - \delta_1)$ is zero, it is possible to set the light transmitted from the polarization board 122 to the maximum value by setting the polarizing direction of the polarization board 122 to the angle $+75^\circ$, i.e. $+45^\circ$ for the direction -60° ($+120^\circ$) of the optical axis at the lower surface. In actuality, the polarization direction is set to an appropriate angle with adjustment by considering another characteristic of the liquid crystal.

In general, when the ordinary ray is overlapped with the extraordinary ray and moved to the same direction, a polarization mode of the light is formed by the oscillation composed with the ordinary ray and extraordinary ray. The intensity of the transmission light determined by the composed polarization mode is changed in accordance with change of the phase difference δ between the ordinary ray and the extraordinary ray along with movement of the light. That is, when there is no rotation of the optical axis, and when the thickness of the liquid crystal layer is "d", the wavelength of the light is λ , and the birefringence which is expressed by the difference $|n_o - n_e|$ between the refractive index "n_o" of the ordinary ray and the refractive index "n_e" of the extraordinary ray is Δn , the phase difference δ becomes " $\delta = 2\pi d \Delta n / \lambda$ ". Further, the intensity I of the transmission light depends on $\sin^2 (\delta/2)$, i.e. $\sin^2 (\pi d \Delta n / \lambda)$, and is changed in

- 11 -

accordance with the thickness "d" of the liquid crystal layer and the wavelength λ of the light.

Next, when there is a rotation of the optical axis, the phase difference is changed depending on the rotational (twisted) angle and direction in addition to the effects of the thickness "d" and change of coordinate. The phase difference δ is determined depending on the above-mentioned $\pi d \Delta n / \lambda$ and the twisted angle (also considering the direction). In this case, since the intensity I of the transmission light depends on $\sin^2 (\delta/2)$, i.e. the phase difference, the intensity is changed depending on the wavelength λ as well as the above explanation. Accordingly, when the liquid crystal layer is one layer, the thickness "d" and the twisted angle are selected in such a way that the intensity I of the transmission light becomes maximum for the light having a particular wavelength λ , and the selected liquid crystal layer is structured. At that time, for the light having different waveform λ from the above light, the intensity I of the transmission light becomes weaker than in the above case. That is, the above liquid crystal layer has a characteristic in which the light having a particular wavelength or a wavelength close to the particular wavelength is selectively transmitted in accordance with the thickness "d" of the liquid crystal layer and the twisted angle. As a result, undesirable and unfavorable color occurs on the screen.

Accordingly, in the case of the present embodiment, the drive cell 101 is overlapped with the correction cell 111, the phase difference δ_1 which occurs at the STN liquid crystal layer 120a1 (normal area) of the drive cell 101 is corrected by the phase difference δ_2 which occurs at the STN liquid crystal layer 120b1 (normal area) of the correction cell 111. In this case, in the

- 12 -

STN liquid crystal layer 120a1 (normal area) and STN liquid crystal layer 120b1 (normal area), by setting the direction of the rotation (twisted) angle to an opposite direction one another, the phase difference $\delta 1$ is equal to the phase difference $\delta 2$, and it is possible to finally set the phase difference ($\delta 1 - \delta 2$) to approximately zero. As a result, it is possible to effectively prevent undesirable and unfavorable color in the normal area.

In this case, when a drive voltage is added between an upper drive electrode 104a and a lower drive electrode 104b of the drive cell, and when the twist of the liquid crystal molecule is changed in the STN liquid crystal layer 120a of the drive cell 101 and reduced, the twist of the polarization passing through this portion is also changed finally, and the angle of the polarization from the STN liquid crystal layer 120b in the correction cell 101. As a result, in the outgoing light from the second polarization film 122, the brightness of the outgoing light passing through the STN liquid crystal layer 120a to which the drive voltage is added becomes different from another portion so that the pattern is displayed in accordance with data.

As shown in Fig. 5, however, there are problems in the conventional liquid crystal device having the correction cell as explained in detail below.

In Fig. 5, in the STN liquid crystal layer 120a of the drive cell 101, the alignment direction (twisted direction of molecule, etc.) of the liquid crystal molecule is normal at the normal area 120a1 of the central portion, and the thickness of the layer (or cell gap) is uniform. On the other hand, in the defective area 120a2 at the peripheral portion, the alignment direction of the liquid crystal molecule is not normal compared to the central portion, and the thickness of the layer is not uniform. Such defects occur for the following reasons. That is, in the vicinity of the seal

- 13 -

member 108, when the seal member 108 is joined with the upper alignment film 105a and the lower alignment film 105b, the hardening and non-hardening impurities are dissolved from the seal member into the liquid crystal.

5 As a result, the impurities affect bad influence to the liquid crystal so that the alignment state of the liquid crystal is changed. Further, the thickness of the alignment film is also changed due to influence of pressed-adhesive processes in the manufacturing line so
10 that the thickness of the liquid crystal layer is also changed. The same defect also occurs in the normal area 120b1 of the STN liquid crystal layer 120b and the defective area 120b2 of the correction cell 111.

Figure 7 is a perspective view for explaining the
15 polarizing direction of each polarization board and the alignment direction (direction of optical axis) at the defective area 120a2 of the STN liquid crystal layer of the drive cell 101 and at the defective area 120b2 of the STN liquid crystal layer of the correction cell 111. In
20 Figs. 5 and 7, S2 is a ray passing through the defective area 120a2 of the drive cell 101 and the defective area 120b2 of the correction cell 111.

In this case, action of the ray S2 will be explained below. In the defective area 120a2 of the drive cell 101
25 and the defective area 120b2 of the correction cell 111, since the alignment of the liquid crystal is not normal as mentioned above, the direction of the optical axis depending on the direction of the liquid crystal molecule becomes irregular. For example, the direction of the
30 optical axis is dispersed in the range of the slanted area in Fig. 7, the birefringence Δn is changed and the thickness is not uniform. Further, the rotational angle of the optical axis may not be set to a predetermined angle, different from the case of the normal area.
35 Accordingly, the phase difference of the transmission light becomes $\delta l'$ which is different from the value δl at

- 14 -

the normal area for the abnormal area 120a2 of the drive cell 101.

In this situation, the ray S2 inputted to the defective area 120b2 of the correction cell 111 suffers the phase difference $\delta 2'$ which is different from the phase difference $\delta 2'$ at the normal area. Further, the final phase difference is set to the value $(\delta 2' - \delta 1')$ and is largely moved from zero due to addition of errors, so that undesirable and unfavorable color occurs on the screen.

Next, as shown in Fig. 5, a part of an effective view-field range 130, which is obtained by observing the range of the normal area 120a1 of the drive cell 101 from the viewpoint P, includes the defective area 120b2 of the correction cell 111 so that this part is colored due to the influence of the phase difference $\delta 2'$. Further, a part of the whole view field area 132, which is obtained by observing the whole area of the seal member of the correction cell 111 from the viewpoint P, includes the defective area 120a2 of the drive cell 101 and the defective area 120b2 of the correction cell 111 which is overlapped with the defective area 120a2 so that this part is affected by the phase differences $\delta 1'$ and $\delta 2'$ and results in dark color. As a result, undesirable and unfavorable color occurs in the peripheral portion of the view field so that the quality of the image deteriorates.

On the other hand, for example, in the Japanese Unexamined Patent Publication No. 2-130531 (liquid crystal display element), a liquid crystal display element having the following structure has been disclosed. That is, a first liquid crystal cell is overlapped with a second liquid crystal cell between the first and second polarization boards, and the outside size of the seal member of the first liquid crystal cell is smaller than that of the seal member. However, this

- 15 -

example aims to improve a working efficiency at the manufacturing of the liquid crystal element by moving the position of an injecting inlet of the liquid crystal of the second liquid crystal cell from the injecting inlet of the first liquid crystal cell. Accordingly, this example does not change the outside size of the seal member in order to resolve undesirable and unfavorable color at the peripheral area of the display panel. Further, in this example, there are no explanation and teaching of a positional relationship of an observer to observe the liquid crystal display panel.

Further, in the Japanese Unexamined Patent Publication No. 2-116825 (liquid crystal display element), a liquid crystal display device, in which a liquid crystal cell for display is overlapped with a liquid crystal cell for an optical compensation, has been disclosed. However, this example includes a light-cutting member formed of a positive-type photo-regist, and there is no disclosure of change of the outside size of the liquid crystal cell in order to resolve undesirable and unfavorable color at the peripheral portion of the display panel. Further, in this example, there are no explanation and teaching for the position relationship of the observer to observe the liquid crystal display panel.

Therefore, as explained in detail below, the present invention aims to provide a liquid crystal display device which can resolve the problem of a liquid crystal panel including a correction cell to correct the phase difference due to the birefringence of the drive cell in a conventional liquid crystal display device, i.e. the problem in which the quality of the display deteriorates due to undesirable and unfavorable color which occurs based on the defective area in the vicinity of the seal member of the liquid crystal cell.

The preferable embodiment will be explained with reference to the attached drawings below. This

- 16 -

embodiment relates to the liquid crystal display device including the liquid crystal panel having the drive cell and the correction cell.

Figure 1 is a cross-sectional view for explaining an essential part of the liquid crystal panel 10 used in the embodiment of the present invention. In Fig. 1, number 1 is a drive cell. In the drive cell 10, number 20a is an STN liquid crystal layer, and is formed by a normal area 20a1 and a defective area 20a2 as mentioned below. The STN liquid crystal layer 20a is held by a transparent upper substrate 2 and a transparent lower substrate 3, and surrounded by a seal member 8. Number 4a is an upper drive electrode, and formed closely to the lower surface of the upper substrate 2. Number 5a is an upper alignment film formed closely to the lower surface of the upper substrate 2 so as to cover the upper drive electrode 4a. Number 4b is a lower drive electrode and formed closely to the upper surface of the lower substrate 3. Number 5b is a lower alignment film formed closely to the upper surface of the lower substrate 3 so as to cover the lower drive electrode 4b.

Number 11 is a correction cell. In the correction cell 11, number 20b is an STN liquid crystal layer, and formed by a normal area 20b1 and a defective area 20b2 as mentioned below. The STN liquid crystal layer 20b is held by a transparent upper substrate 12 and a transparent lower substrate 13, and is surrounded by a seal member 8. Number 15a is an upper alignment film formed closely to the lower surface of the upper substrate 12. Number 15b is a lower alignment film formed closely to the upper surface of the lower substrate 13. The correction cell 11 has no drive electrode different from the drive cell 1, but it may include the drive electrode.

An inside size of the seal member of the correction cell 11 is sufficiently larger than the inside size of the drive cell 1, and the inside size (outside size of

- 17 -

the normal area 20b1) of the defective area 20b2 of the correction cell 11 is sufficiently larger than the defective area 20a2 of the drive cell 1. The lower substrate 3 of the drive cell 1 is arranged on the upper substrate 12 of the correction cell 11, and the liquid crystal display device includes the correction cell 11 and the drive cell 1. At that time, the positioning is executed in such a way that the defective area 20a2 of the drive cell 1 is overlapped with the normal area 20a1 of the drive cell 1 in the range of the normal area 20b1 of the correction cell 11. That is, defective area 20a2 of the drive cell 1 is not overlapped with the defective area 20b2 of the correction cell 11 in the present invention.

Number 21 is a first polarization board, and is arranged closely to or opposite to the outside (upper side) of the upper substrate 2 of the drive cell 1. Number 22 is a second polarization board, and is arranged closely to or opposite to the outside (lower side) of the lower substrate 13 of the correction cell 11. As shown in Fig. 1, the liquid crystal panel 10 includes the drive cell 1, the correction cell 11, the first polarization board 21 and the second polarization board 22.

In the above structure, the action of the liquid crystal panel 10 will be explained with reference to Fig. 1. First, the action of the ray S1 is explained below. The ray S1 is input from the outside to the first polarization board 21, and passes through the normal area 20a1 of the drive cell 1, the normal area 20b1 of the correction cell 11 and the like. Finally, the ray S1 is output from the second polarization board 22 to the outside. This action is the same as the ray S1 explained in Figs. 5 and 6 in the conventional art. Based on the same principle, the phase difference $\delta 1$ of the ordinary ray and the extraordinary ray occurred in the STN liquid crystal layer 20a1 (normal area) of the drive cell 1 is

- 18 -

corrected by the phase difference $\delta 2$ occurred in the STN liquid crystal layer 20b1 (normal area) of the correction cell 11. That is, the phase differences $\delta 1$ and $\delta 2$ are approximately equal to one another, and the final phase difference ($\delta 2 - \delta 1$) can be set to approximately zero. As mentioned above, it is possible to resolve undesirable and unfavorable color at the normal area in the present invention.

Next, the difference points between the present invention and the conventional art will be explained below. As shown in Fig. 1, the action of the ray S2, which is input from the outside to the first polarization board 21 and passes through the defective area 20a2 of the drive cell 1, is explained below. In this embodiment, as explained above, the defective area 20a2 of the drive cell 1 is not overlapped with the defective area 20b2 of the correction cell 11, and overlapped with only the normal area 20b2. Accordingly, the ray S2 passes through the normal area 20b1 of the correction cell, and is finally output from the second polarization board 22 to the outside.

When the ray S2 passes through the defective area 20a2 of the drive cell 1, the phase difference $\delta 1'$, which is different from the phase difference $\delta 1$ occurring in the normal area 20a1, occurs based on the same principle as explained in Figs. 5 and 7. When the ray S2 passes through the normal area 20b1 of the correction cell 11, a new phase difference $\delta 2'$ occurs based on the same principle as explained in Figs. 5 and 6, so that the final phase difference ($\delta 2' - \delta 1'$) can be obtained. This phase difference is moved from zero, and results in color based on the above-explained principle.

As explained above, the ray S2, which passes through the abnormal area 20a2 of the drive cell 1, is slightly colored differently from the ray S1 that passes through

- 19 -

the normal area 20a1 of the drive cell 1. However, in the case of this embodiment, since there is no overlapping of the cells as explained in the conventional art between the defective areas, the final phase difference is affected only by movement due to the abnormal area 20a2 of the drive cell 1. Further, in the conventional art of Fig. 5, since both abnormal areas of the drive cell and correction cell are overlapped, the influence of both abnormal areas is added to the final phase difference for the transmission light of the abnormal area so that the ray is largely moved from zero. Accordingly, in this embodiment, since the brightness of the abnormal area is different from the normal area, the abnormal area is slightly colored. However, the grade of color becomes considerably smaller compared to the conventional art, and has an allowable range from the viewpoint of quality of image.

Next, as shown in Fig. 1, the defective area 20b2 is not included in a part of the range of the effective view field which is obtained by observing the range of the normal area 20a1 of the drive cell 1 from the view point P, and the part of the range of the effective view field is not colored. Further, although the defective area 20a2 is included in the part of the whole view field area 32 which is obtained by observing the whole area of the seal member of the correction cell 11 from the view point P, the defective area 20b2 of the correction cell is not included in the part of the view field so that the color of the peripheral portion of the whole view field area 32 becomes light compared to the conventional art. As a result, the quality of image, which is observed from the view point P, is considerably improved compared to the conventional art.

Another embodiment according to the present invention will be explained with reference to the drawings below. This embodiment is a modified type of the liquid crystal display device as explained in Fig. 1.

- 20 -

Figure 2 is a cross-sectional view for explaining a main structure of the liquid crystal panel according to the embodiment of the present invention. The liquid crystal panel of this embodiment is structured in such a way that the incident light is input from the correction cell 11 and output from the drive cell 1. Further, the difference "dL" in size, which is obtained by the difference between the size of the normal area 20b1 of the correction cell 11 and the outside size (or an inside size of the seal member) of the defective area 20a2 of the drive cell 1, satisfies predetermined conditions. In this case, reference numbers of the structural members in Fig. 2 are the same as those of Fig. 1.

Based on the above structure, the action of this embodiment will be explained below. When the light is input from the lower side of the second polarization board 22, the transmission light is output from the first polarization board 21 through a light path opposite to the liquid crystal panel shown in Fig. 1. This is basically similar to a characteristic of the final outgoing light of the liquid crystal panel shown in Fig. 1. In this embodiment of the liquid crystal panel, however, consideration for relationship of the size is provided as explained below.

As one relationship of the size, when an angle of the maximum view field based on an inside end of the seal member 8 of the liquid crystal is θ_s ; when the thickness of the lower substrate 3 of the drive cell 1 is t_1 , and the thickness of the upper substrate 12 of the correction cell 11 is t_2 ; when the thickness (or cell gap) of the STN liquid crystal layer 20b1 of the correction cell 1 is "d"; and when the distance, which is determined as the boundary of the normal area 20b1 of the correction cell 11 being moved to the outside from the boundary of the seal member 8 of the drive cell 1 and the defective area 20a2, is "dL"; it is necessary for these conditions to have the following relationship, i.e.

- 21 -

$$dL > (t1 + t2 + d) \cdot \tan \theta_s \quad \dots\dots(1)$$

When the relationship of the formula (1) is satisfied, the light, which passes through the defective area 20a2 of the drive cell 1 and is output to the direction of the view field θ_s , is transmitted through the normal area 20b1 of the correction cell 11 and is not transmitted through the defective area 20b2. As a result, the influence of two defective areas 20a2 and 20b2 is not added to the outgoing light, and it is possible to achieve the purpose of the present invention in the range of the angle of the maximum view field θ_s . In the formula (1), a curve (a move from a straight line) due to the refraction of the transmission light and the thickness of the alignment films 5b, 15a are negligible because of small values.

As another relationship of the size, when the range of clear vision based on the lower surface of the STN liquid crystal layer 20a1 of the drive cell 1 is "mL"; when the width of the sealed space (inside of the seal member) of the drive cell 1 is "wL"; when the thickness of the lower substrate 3 of the drive cell 1 is t1 and the thickness of the upper substrate 12 of the correction 11 is t2; when the thickness (or cell gap) of the STN liquid crystal layer 20b1 is "d"; and when the distance, which is determined as the boundary of the normal area 20b1 of the correction cell 11 being slipped to the outside from the boundary of the seal member 8 of the drive cell 1 and the defective area 20a2, is "dL"; it is necessary for these conditions to have the following relationship, i.e.

$$dL / (t1 + t2 + d) > wL/mL \quad \dots\dots(2)$$

When the relationship of the formula (2) is satisfied, the light, which passes through the defective area 20a2 of the drive cell 1 and passes through the range (mL) of clear vision in the front of the liquid crystal panel, is transmitted through the normal

- 22 -

area 20b1 of the correction cell 11 and is not transmitted through the defective area 20b2. As a result, when the liquid crystal panel is observed from the range (mL) of clear vision, it is possible to observe the display image having few defects based on the same reasons as above.

In this case, the embodiment of the present invention shown in Fig. 2 has the relationship of the size which satisfies both formulas (1) and (2). In the present invention, however, the present invention is not limited above, and may have the relationship of size which satisfies any one of the formulas (1) and (2).

Still another embodiment of the present invention will be explained with reference to the drawings below. This embodiment is a modified type of the liquid crystal device shown in Fig. 1. Figure 3 is a cross-sectional view for explaining the structure of the liquid crystal panel according to this embodiment. Figure 4 is a cross-sectional view for explaining the modified type of the liquid crystal panel shown in Fig. 3. As shown in Fig. 3, in this embodiment, the inside size of the seal member of the drive cell 1 is larger than the inside size of the seal member of the correction cell 11, the defective area 20b2 of the correction cell 11 is overlapped with the normal area 20b1 in the normal area of the drive cell 1, and the defective area 20a2 of the drive cell 1 is not overlapped with the defective area 20b2 of the correction cell 11.

Others are the same as the embodiment shown in Fig. 1. As the ray which is transmitted through the liquid crystal panel 10 in this embodiment, there are two rays, i.e. the ray S1 being transmitted through the normal area 20b1 of the correction cell 11 and the ray S2' being transmitted through the defective area 20b2 of the correction cell 11. The ray S1 is transmitted through only the normal area, and has the same characteristic as the ray S1 shown in Fig. 1. The

- 23 -

ray S2' is transmitted through the normal area and defective area, and has the same characteristic as the ray S2 shown in Fig. 1. Accordingly, it is possible to achieve the display image having little defects caused by the defective area in this embodiment.

Next, in Fig. 4, number 24 is a partition board on the second polarization board 22. Others are the same as the embodiment shown in Fig. 3. As shown in Fig. 4, the defective area 20a2 of the drive cell 1 is not included in the range of the effective view field which is obtained by observing the range of the normal area 20b1 of the correction cell 11 from the view point P, and there is no color in a part of the range of the effective view field. Further, in the whole area of the seal member of the correction cell 11 observed from the view point P, although the defective area 20b2 of the correction cell 11 is included in a part of the whole view field area 32 separated by the partition board 24, the defective area 20a2 of the drive cell 1 is not overlapped with the view field area. Accordingly, the color in the peripheral portion of the whole view field area 32 is light compared to the conventional art. As a result, the quality of image, which is observed from the view point P, is considerably improved compared to the conventional art.

In the above embodiment, although the explanation is given to the case in which the drive cell is combined with the correction cell, it is possible to obtain the same effect as the above embodiment in the case that two drive cells are overlapped. Further, in the above embodiment, although the explanation is given to the case in which two display cells are overlapped, it is possible to obtain the same effect as the above embodiment in the case that a plurality of display cells, for example, three cells, four cells, etc. are overlapped, by structuring in such a way that the display area of the display cell provided away from the observer is gradually

- 24 -

formed wider than the display area of the display cell provided at the observer's side.

POSSIBILITY OF UTILIZATION IN INDUSTRY

5 According to the present invention, in the liquid
crystal display device including the display panel having
the correction cell to correct the phase difference due
to the birefringence of the drive cell, it is possible to
10 resolve the defect of display due to undesirable and
unfavorable color which occurs based on the defective
area in the vicinity of the inside of the seal member of
the drive cell and the correction cell. As a result, the
present invention can be utilized widely as a simple
15 display means or a display means used in computers or
communication equipments having a thin shape and low
power consumption using the TN liquid crystal or the STN
liquid crystal utilizing rotatory power of the liquid
crystal. Further, when the observer observes the display
20 device from the upper side, although the lower display
cell is observed rather more widely than the upper
display cell, it is possible to provide the liquid
crystal device which can resolve the difference in the
range observed by the observer so that the possibility of
utilization in industry is very good.

09/889319

JC18 Rec'd PCT/PTO 13 JUL 2001

- 25 -

(REPLACEMENT)

CLAIMS

1. (AMENDED) A display device including at least one display cell sealed by one seal member in which an electro-optical converting member is held by two substrates, and having a defective area and normal area in the inside of the seal member; another at least one display cell sealed by another seal member in which the electro-optical converting member is held by two substrates, and having the defective area and normal area in the inside of the seal member; and these display cells being overlapped; characterized in that,

the display cell provided to an opposite side of an observer has an normal area, which is wider than the display cell provided to a side of the observer.

2. (AMENDED) A display device as claimed in claim 1, characterized in that the display cell is a liquid crystal display cell in which the electro-optical converting member consists of a liquid crystal.

3. (AMENDED) A display device as claimed in claim 2, characterized in that the display device is formed by overlapping two liquid crystal display cells, and at least one liquid crystal display cell is a drive cell to which a liquid crystal drive voltage is applied.

4. (AMENDED) A display device as claimed in claim 2, characterized in that the display device is formed by overlapping two liquid crystal display cells, one liquid crystal display cell is a drive cell to which a liquid crystal drive voltage is applied, and the other liquid crystal display cell is a correction cell to which the liquid crystal drive voltage is not applied.

- 26 -

5. (AMENDED) A display device as claimed in claim 4, characterized in that, in the drive cell and the correction cell, one of inside sizes of the seal member of the drive cell and the seal member of the correction cell is larger than the other inside size.

6. (AMENDED) A display device as claimed in claim 4, characterized in that, in the drive cell and the correction cell, one of sizes of an effective display area of the drive cell and an effective display area of the correction cell is larger than the other size of the effective area.

7. (AMENDED) A display device as claimed in claim 5 or 6, characterized in that the liquid crystal panel is structured by overlapping the drive cell with the correction cell, in the form that the defective area having defects of cell-gap and/or of alignment in the vicinity of the inside of the seal member of the drive cell is overlapped in the range of the normal area having no defect of the correction cell.

8. (AMENDED) A display device as claimed in claim 5 or 6, characterized in that the liquid crystal panel is structured by overlapping the drive cell with the correction cell, in the form that the defective area having defects of cell-gap and/or of alignment in the vicinity of the inside of the seal member of the correction cell is overlapped in the range of the normal area having no defect of the correction cell.

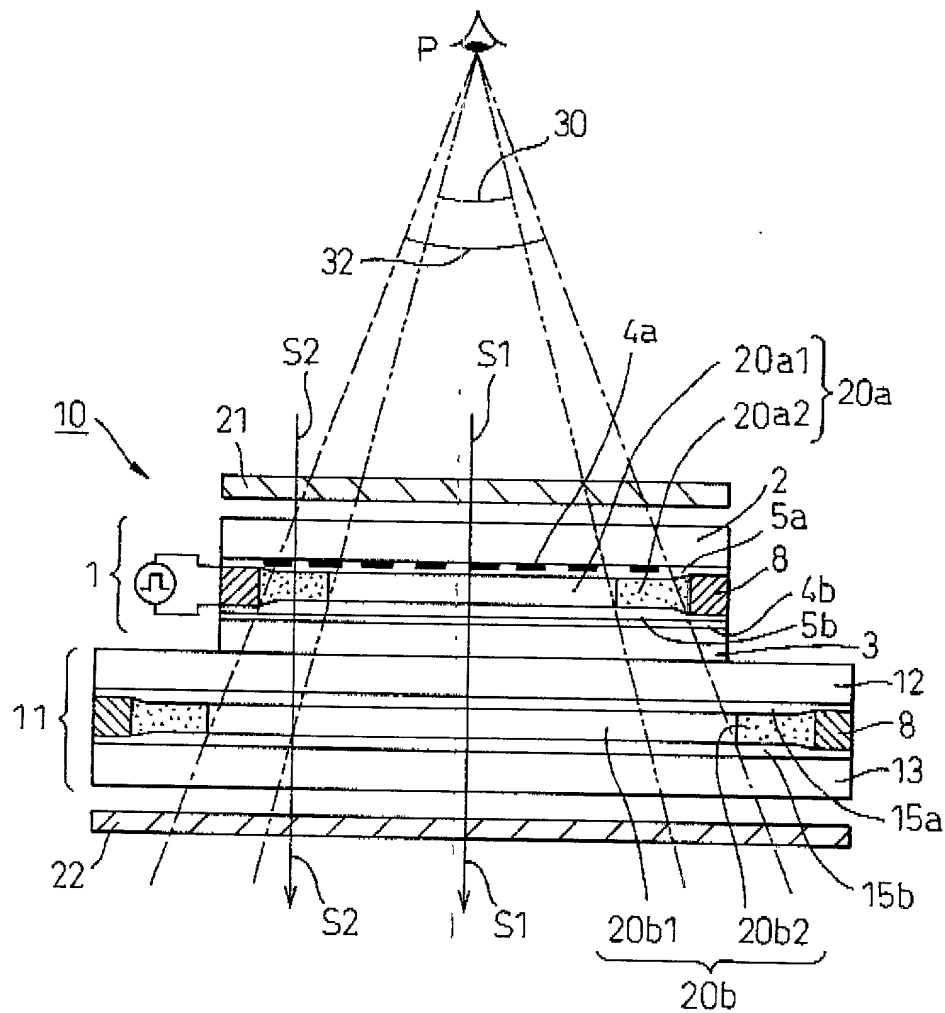
- 27 -

9. (DELETED)

10. (AMENDED) A display device as claimed in any one of claims 2 to 8, characterized in that the liquid crystal is an STN liquid crystal.

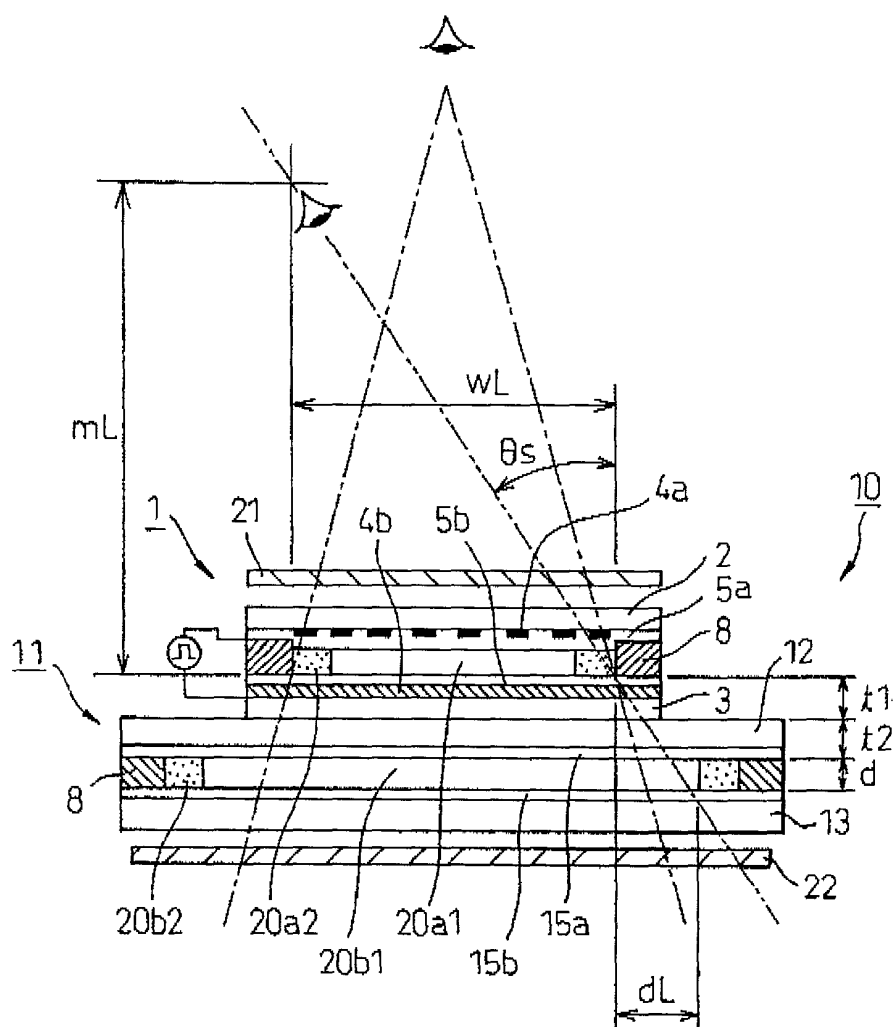
09/889319

Fig.1



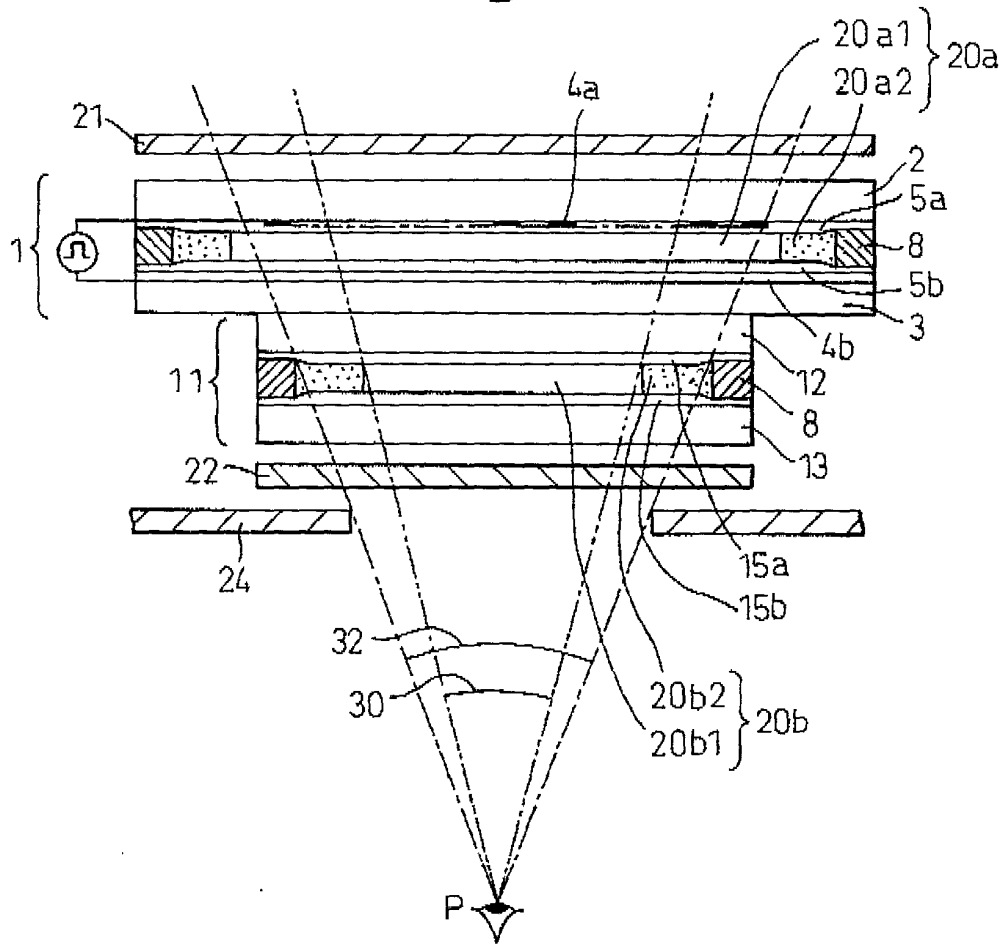
09/889319

Fig.2



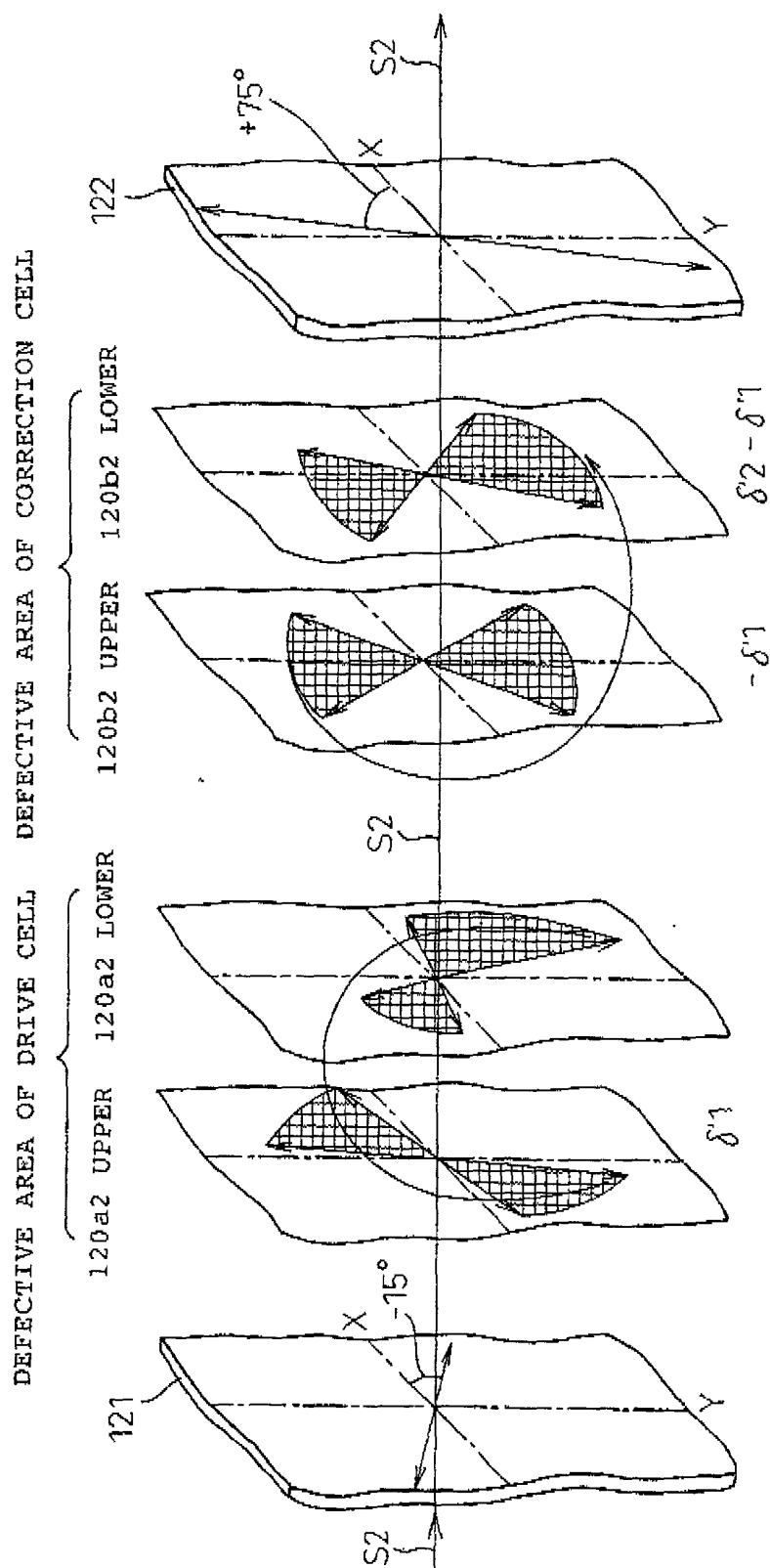
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Fig.4



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Fig.7



09/889319

LIST OF REFERENCE NUMBERS

- 1: drive cell
- 2, 12: upper substrate
- 3, 13: lower substrate
- 4a: upper drive electrode
- 4b: lower drive electrode
- 5, 15: alignment film
- 8: seal member
- 10: liquid crystal panel
- 11: correction cell
- 20a, 20b: STN liquid crystal layer
- 20a1, 20b1: normal area
- 20a2, 20b2: defective area
- 21: first polarization board
- 22: second polarization board
- 24: partition board

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日本語宣言書

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My residence, post office address and citizenship are as stated next to my name.

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I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled

A DISPLAY DEVICE

上記発明の明細書（下記の欄でx印がついていない場合は、本書に添付）は、

the specification of which is attached hereto unless the following box is checked:

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as United States Application Number or
PCT International Application Number
PCT/JP00/08094 and was amended on
March 30, 2001 (if applicable).

私は、特許請求範囲を含む上記訂正後の明細書を検討し、内容を理解していることをここに表明します。

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

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Prior Foreign Application(s)

外国での先行出願

11-325316(Pat. Appln.)

Japan

(Number)

(Country)

(番号)

(国名)

(Number)

(Country)

(番号)

(国名)

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(Application No.)

(Filing Date)

(出願番号)

(出願日)

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(Application No.)

(Filing Date)

(出願番号)

(出願日)

(Application No.)

(Filing Date)

(出願番号)

(出願日)

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Priority Not Claimed

優先権主張なし

16/November/1999

(Day/Month/Year Filed)

(出願年月日)

(Day/Month/Year Filed)

(出願年月日)

I hereby claim the benefit under Title 35, United States Code, Section 119(e) of any United States provisional application(s) listed below.

(Application No.)

(Filing Date)

(出願番号)

(出願日)

I hereby claim the benefit under Title 35, United States Code, Section 120 of any United States application(s), or 365(c) of any PCT International application designating the United States, listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States or PCT International application in the manner provided by the first paragraph of Title 35, United States Code Section 112, I acknowledge the duty to disclose information which is material to patentability as defined in Title 37, Code of Federal Regulations, Section 1.56 which became available between the filing date of the prior application and the national or PCT International filing date of application.

(Status: Patented, Pending, Abandoned)

(現況: 特許許可済、係属中、放棄済)

(Status: Patented, Pending, Abandoned)

(現況: 特許許可済、係属中、放棄済)

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

Japanese Language Declaration

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